

June 28, 2016 10:29:30 AM

Item ID: D2896-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 6/30/2016 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 7/15/2016 **Req'd Qty:** 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: SLA Date: 6/28/16 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2896	C

100

0.04

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

0.60

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA167

Folio Rev: AA

Dwg Rev: C

Deburr

*****Program Batch #*****

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

OC

Memo

0.00

Quality Control

DAS
14
9-89

16/07/15

DAS
14
9-29

16/07/11

DQA:

Date: 16.08.09



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed

Date: 16/07/20

Work Order update only ☐

Work Order: 148418		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. D2896-1		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. 16-5925		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: 16/07/11		Step #: 100		QTY Effective: 1				MRB (081042) Approval	
				+2.6				16.07.11	
Description Work Order Deviation				Disposition				Completed By	
1 blank (2 parts) scrap. Tool holder machine the part				scrap and destroy				DAS 14 16/07/11	
R.C. forgot to change parameter in the computer operator error.				replace Qty 1				Lead hand / Supervisor Approval Verification	
				Batch 145622				PD 16-07-15	
								QC / QA Coordinator Approval	
								DAS 16 16/07/15	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☒	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 2/11/15 Date: 16/07/2015Work Order update only ☐

Work Order: <u>148418</u> Part No. <u>02896-1</u> NCR No. <u>16-5926</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>16/07/15</u>	Step #: <u>100</u>	QTY Effective: <u>1</u>		MRB (QSI042) Approval DAS 12 9-89																																																																
Description Work Order Deviation		Disposition		Completed By <u>[Signature]</u> <u>16/07/15</u> Lead hand / Supervisor Approval Verification <u>9</u> <u>9-89</u> <u>16-07-15</u> QC / QA Coordinator Approval 16 9-89 <u>16/07/15</u>																																																																
<u>1 part, the 0.625" bore perpendicular to 1.764 was .0075, .0025 over tol.</u>		<u>SCRAP & destroy.</u> <u>no replant.</u>																																																																		
Root Cause <table style="width:100%; font-size: x-small;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☒</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☒</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☒	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☒	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; font-size: x-small;"> <tr><td>Pressure/Forced ☐</td><td>Temperature/Cure ☐</td><td>Power Loss/Surge ☐</td><td>Positioned Wrong ☐</td></tr> <tr><td>Bending ☐</td><td>Set-up ☐</td><td>Folio/Program ☐</td><td>Outside Dimensions ☐</td></tr> <tr><td>Centre Not Concentric ☐</td><td>BOM/Route ☐</td><td>Grain ☐</td><td>Over/Under tolerance ☐</td></tr> <tr><td>Cracks ☐</td><td>Broken/Damage/Defect ☐</td><td>Weld ☐</td><td>Part Incorrect ☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave ☐</td><td>Inspection Incomplete/Unqualified ☐</td><td>Wrong Stock Pulled ☐</td><td>Part Lost/Missing ☐</td></tr> <tr><td>Cuffs ☐</td><td>Contamination ☐</td><td>Out of Sequence ☐</td><td>Part Moved ☐</td></tr> <tr><td>Crushing ☐</td><td>Countersink ☐</td><td>Off-set ☐</td><td>Drawing ☐</td></tr> <tr><td>Heat Treat ☐</td><td>Cut Too Short ☐</td><td>Mislabeled ☐</td><td>Finish ☐</td></tr> <tr><td>Wave/Twist in Tube ☐</td><td>Instructions Incomplete/Unclear ☐</td><td>Fit/Function ☐</td><td>Misread ☐</td></tr> <tr><td>Marks/Chatter ☐</td><td>Drill Holes ☐</td><td>☒ Misaligned/off center</td><td>Turning Sequence ☐</td></tr> </table>			Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	☒ Misaligned/off center	Turning Sequence ☐
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		OTHER: _____																																																																		

Work Order ID 148418

June 28, 2016 10:29:30 AM

148418

Page 2

Item ID: D2896-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support
Start Date: 6/30/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/15/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				9	0		DAS 20 9-89 16-07-16
120									
QC	Memo	0.03							
Quality Control									
130	Identify as per dwg & Stock Location: <u>LG51</u>	0.00				9			DAS 41 9-89 16-7-18
130									
Packaging	Memo	0.02							
Packaging	LOCATION : LG053								
140	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89 JUL 18 2016
140									
QC	Memo	0.17							
Quality Control									

DAS
21
9-89

JUL 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

June 28, 2016 10:29:35 AM

Page 1

Work Order ID: 148418

148418

Parent Item: D2896-1

D2896-1

Parent Item Name: Support

Start Date: 6/30/2016

Required Date: 7/15/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B02.11.26Reformat; Added P/O; Added mask holeKJ

IPP Rev:C As per Rev B 07-04-16 JLM

IPP D 08.03.19 Re-format EC verified by DD

IPP REV:E

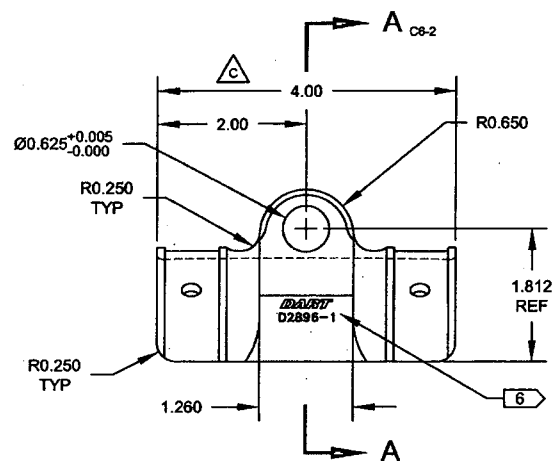
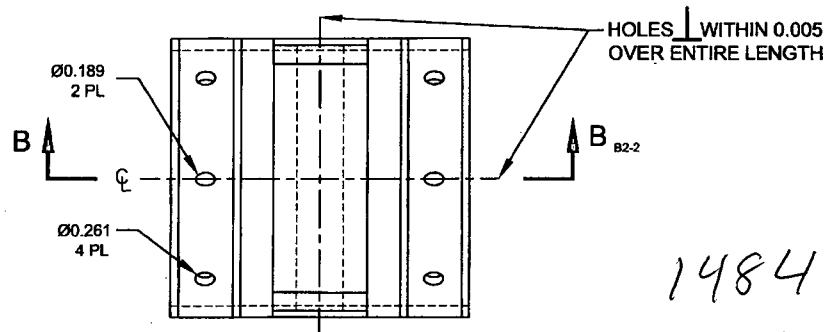
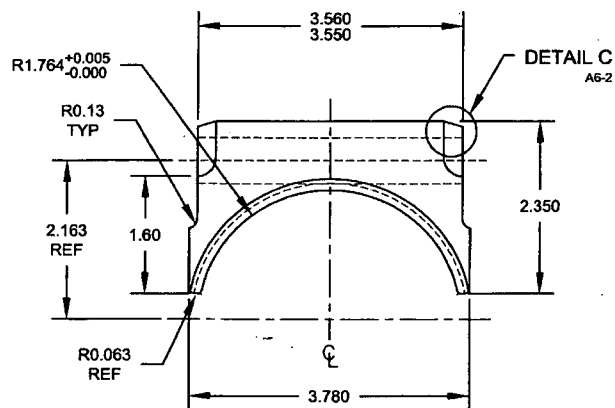
11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK080		Manufactured	No			100	Each	0.0000	0.5	5		DAS	
DSK080									**	5		20	
D2896-1 Turning Detail												16-07-08	

am 16/07/10

148643, 5

145622 1 NOT REMOVE



D2896-1 SUPPORT

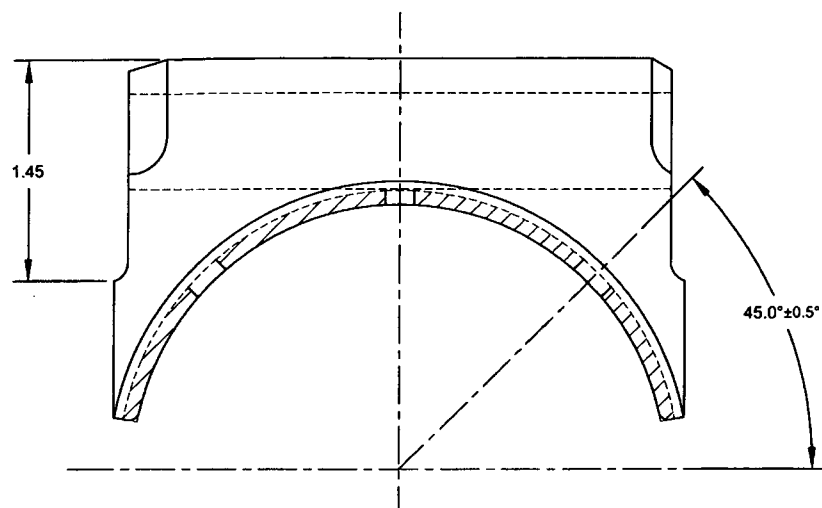
NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP PER DART QSI 044 6.3
- 7) WEIGHT: 1.76 lbs

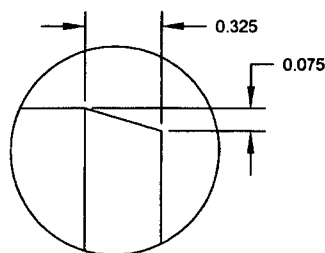
C	RMV FINISH & UPDATE MAT'L SPEC (A8-1), 2.00 WAS 2.000, 4.00 WAS 4.000 (C4-1), REFORMAT DWG	CP	11.09.07
B	INCORP. A1-A4, FINISHING NOTES	PH	07.03.19
A	NEW ISSUE	CP	01.10.19
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DP		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	DP	D2896	SHEET 1 OF 2
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	SUPPORT	NTS
DATE	11.09.07	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2011-09-29

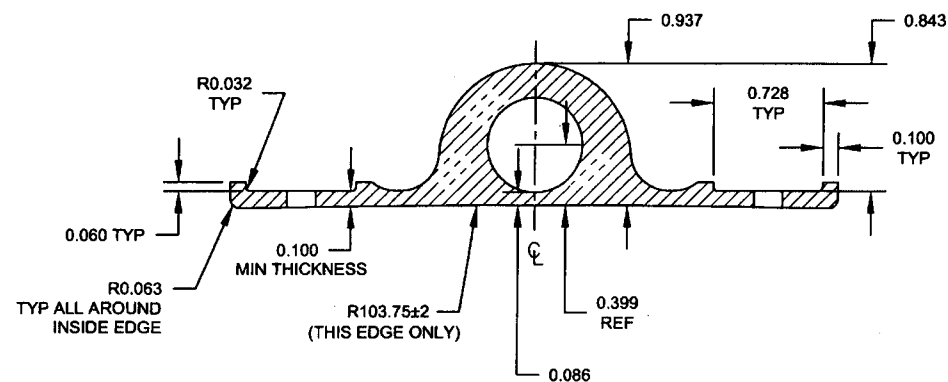
148418
SA 148418



SECTION A-A C3-1
TOOLING HOLE DETAIL
SCALE 2X



DETAIL C C6-1
SCALE 4X



SECTION B-B D3-1
SCALE 2X

RELEASED
2011-09-29

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2896	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
DATE	11.09.07	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE SUPPLIER'S CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 148418
Description: Support		Part Number: D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.152	2.172		2.160	2.162	2.160	2.166	2.157
AB	2.340	2.360		2.352	2.345	2.349	2.350	2.349
AC	3.550	3.560		3.555	3.555	3.556	3.557	3.553
AD	3.770	3.790		3.784	3.784	3.785	3.786	3.783
AE	0.065 x 0.315	0.085 x 0.335		.070 x .315	.070.315	.070 x .320	.070 x .315	.072 x .330
AF	1.42	1.48		1.446	1.445	1.452	1.451	1.450
AG	0.833	0.853		.842	.845	.843	.843	.845
AH	0.240	0.260		.250	.250	.250	.250	.250
AI	0.261	0.266		.263	.263	.262	.262	.262
AJ	0.189	0.194		.191	.191	.191	.191	.191
AK	1.970	2.030		2.000	1.992	2.002	2.003	2.003
AL	0.625	0.630		.626	.626	.626	.626	.625
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.940	.940	.938	.938	.940
AP								
AQ								
AR								

Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"

Accept/Reject	.0045	.0015	.004	.0025	.003
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Measured by: DAS 14	Date: 16/07/10
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Audited by: DAS 20	Date: 16-07-10
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	

DART AEROSPACE LTD		Work Order:	148418
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
HAAS Section								
AA	2.152	2.172		2.162	2.162	2.162	2.161	2.164
AB	2.340	2.360		2.351	2.351	2.348	2.350	2.351
AC	3.550	3.560		3.555	3.553	3.555	3.552	3.551
AD	3.770	3.790		3.783	3.783	3.783	3.782	3.782
AE	0.065 x 0.315	0.085 x 0.335		0.070 x 0.330	0.070 x 0.330	0.070 x 0.330	0.070 x 0.320	0.070 x 0.320
AF	1.42	1.48		1.453	1.451	1.453	1.450	1.458
AG	0.833	0.853		.842	.843	.842	.840	.841
AH	0.240	0.260		.250	.250	.250	.250	.250
AI	0.261	0.266		.263	.263	.263	.263	.263
AJ	0.189	0.194		.191	.191	.191	.191	.191
AK	1.970	2.030		2.007	2.002	2.007	2.008	2.004
AL	0.625	0.630		.625	.625	.625	.625	.625
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.938	.940	.938	.938	.938
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				.002	.002	.003	.002	.0075

Measured by:	DAS 14 2-20 DAS	Date:	16/07/11
Audited by:	20 16-07-16 9-89	Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	